








Work Order ID 52227

Monday, September 21, 2009 11:41:27 AM



Page 1

Item ID: D3315-5 *GY* Accept  Setup Start 
Revision ID: B Stop 
Item Name: Wearplate
Start Date: 9/21/2009 Start Qty: 6.00  Cust Item ID:
Required Date: 10/2/2009 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: *BL-MK* Date: *09-21* Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3315	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315 ☒ Dwg Rev: *B* ☐ Prog Rev: *B* ☐ 2-
Deburr if necessary*B 9-9-25**(7)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-9-25

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*2/509/02/05**(47)*

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Page 2

Item ID: D3315-5	Accept		Setup	Start	
Revision ID: B				Stop	
Item Name: Wearplate					
Start Date: 9/21/2009	Start Qty: 6.00		Cust Item ID:		
Required Date: 10/2/2009	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____






Run	Start	
	Stop	



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo 1- Form using DT8751 Die as per Dwg D3315Rev: <u>B</u> 2- Form using <u>809/10/01</u> DT8179 Die as per Dwg D3315Rev: <u>B</u>	0.00 0.00				<u>7</u>	<u>0</u>		
140 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				<u>5</u> <u>(47)</u>	<u>4</u>		
150 Large Fab Large Fab	Large Fab Memo Weld hard surface using D3315-5T3 as per QSI 004 and Dwg D3315 Rev: ____ Qty Part Number Description Batch ____ A/R N/A 7560 Hardcoat Rod <u>M109 060</u>	0.00 0.00				<u>EL</u>	<u>9-10-7</u>	<u>(X7)</u>	




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Page 3

Item ID: D3315-5	Accept		Setup	Start	
Revision ID: B				Stop	
Item Name: Wearplate					
Start Date: 9/21/2009	Start Qty: 6.00		Cust Item ID:		
Required Date: 10/2/2009	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	=> S or 10/10/07			(X7)	/		
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	=> S or 10/10/07			(X7)	/		
180  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M 140091 Memo START TIME: 11:45 FINISH TIME: 12:15	0.00 0.00	Bk 09-10-8			(7)			

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Page 4

Item ID: D3315-5

Accept

Revision ID: B

Item Name: Wearplate

Start Date: 9/21/2009 Start Qty: 6.00

Required Date: 10/2/2009 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190



QC

Quality Control

QC3- Inspect Part Finish

0.00

W 09/10/09

Memo

0.00

(X7)

Q

200



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify on inside surface using a permanent fine point marker with the following: ☐TCCA-PDA, Dart Aerospace Ltd. ☐P/N: D3315-5, B/N: BXXXXX ☐For Product Eligibility see PDA04-17 ☐and Stock ☐Location: 496 A

9/10/9 (40) SP

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/10/13 JH
MF 09-10-09

Picklist Print

Page 1

Monday, September 21, 2009 11:41:26 AM

Work Order ID: 52227



Parent Item: D3315-5RevB



Parent Item Name: Wearplate



Start Date: 9/21/2009

Required Date: 10/2/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010S16GA		Purchased	No			100	sf	111.6200	11.5863			
												
1010/1025 sheet 16GA												

B9-9-25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111.62

105706

0.6

111410

111.02

105706

DART AEROSPACE LTD		Work Order: 52227
Description: Wearplate		Part Number: D3315-5
Inspection Dwg: D3315 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.31	+/-0.030	34.31	x			
30.215	+/-0.010	30.215	x			
24.215	+/-0.010	24.215	x			
21.611	+/-0.010	21.611	x			
17.965	+/-0.010	17.965	x			
16.026	+/-0.010	16.026	x			
14.735	+/-0.010	14.735	x			
12.815	+/-0.010	12.815	x			
6.465	+/-0.010	6.465	x			
5.464	+/-0.010	5.466	x			
4.527	+/-0.010	4.530	x			
3.550	+/-0.010	3.547	x			
5.214	+/-0.010	5.206	x			
Ø0.300	+0.006/-0.001	.305	x			
Ø0.266 x 0.575	+/-0.010	.266 x .579	x			
Ø0.266 x 0.450	+/-0.010	.268 x .452	x			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-9-28	Date: 9/10/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	

DARTSHOT COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

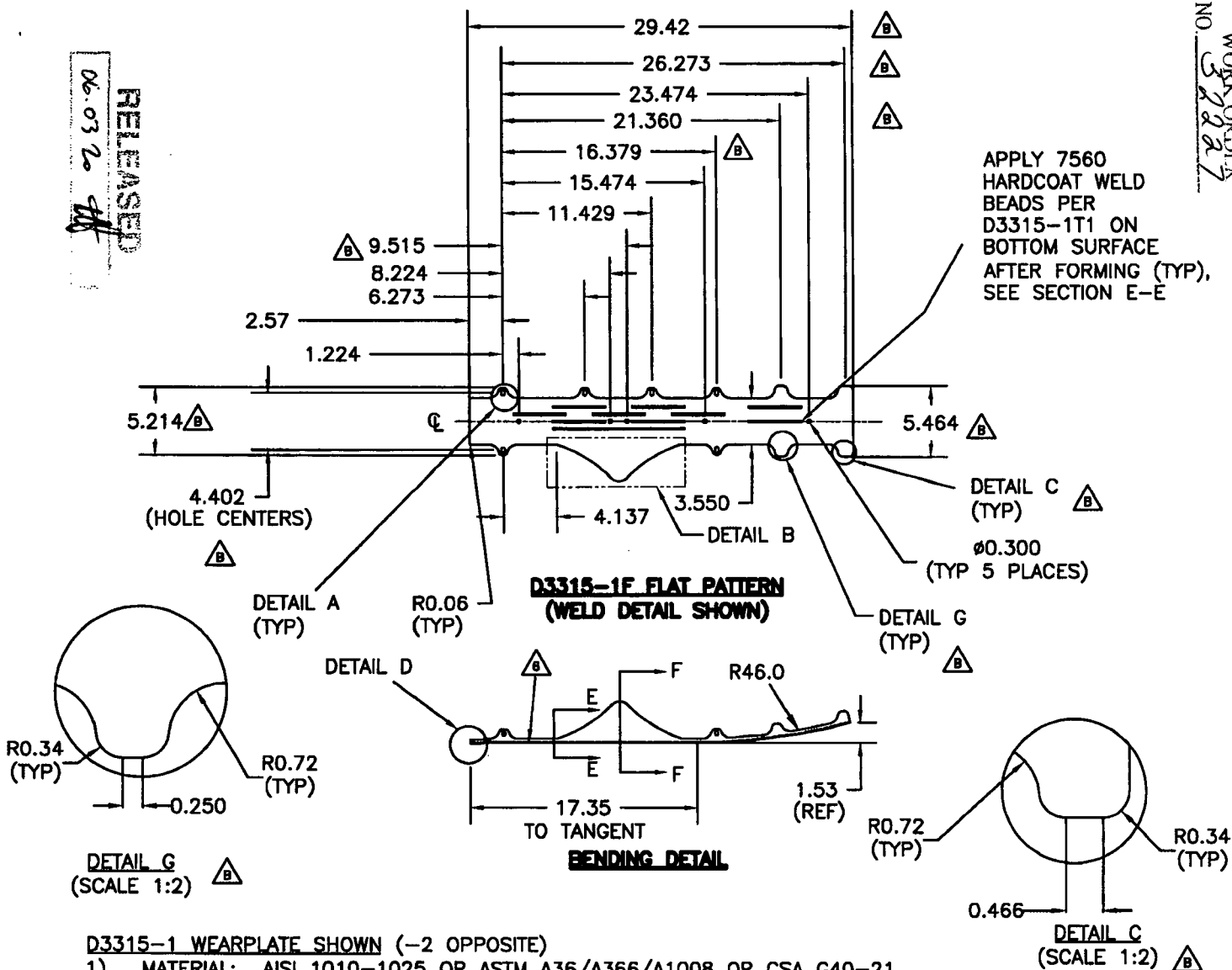
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 32227

APPLY 7560
HARDCOAT WELD
BEADS PER
D3315-1T1 ON
BOTTOM SURFACE
AFTER FORMING (TYP),
SEE SECTION E-E

**D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	DRAWN BY	DART AEROSPACE LTD
GH	GH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
GH	GH	D3315
DATE	TITLE	REV. B
06.01.31	WEARPLATE	SHEET 1 OF 4
A	04.09.10	NEW ISSUE
B	06.01.31	UPDATE DIMENSIONS
		SCALE 1:12

RELEASED

06.03.20

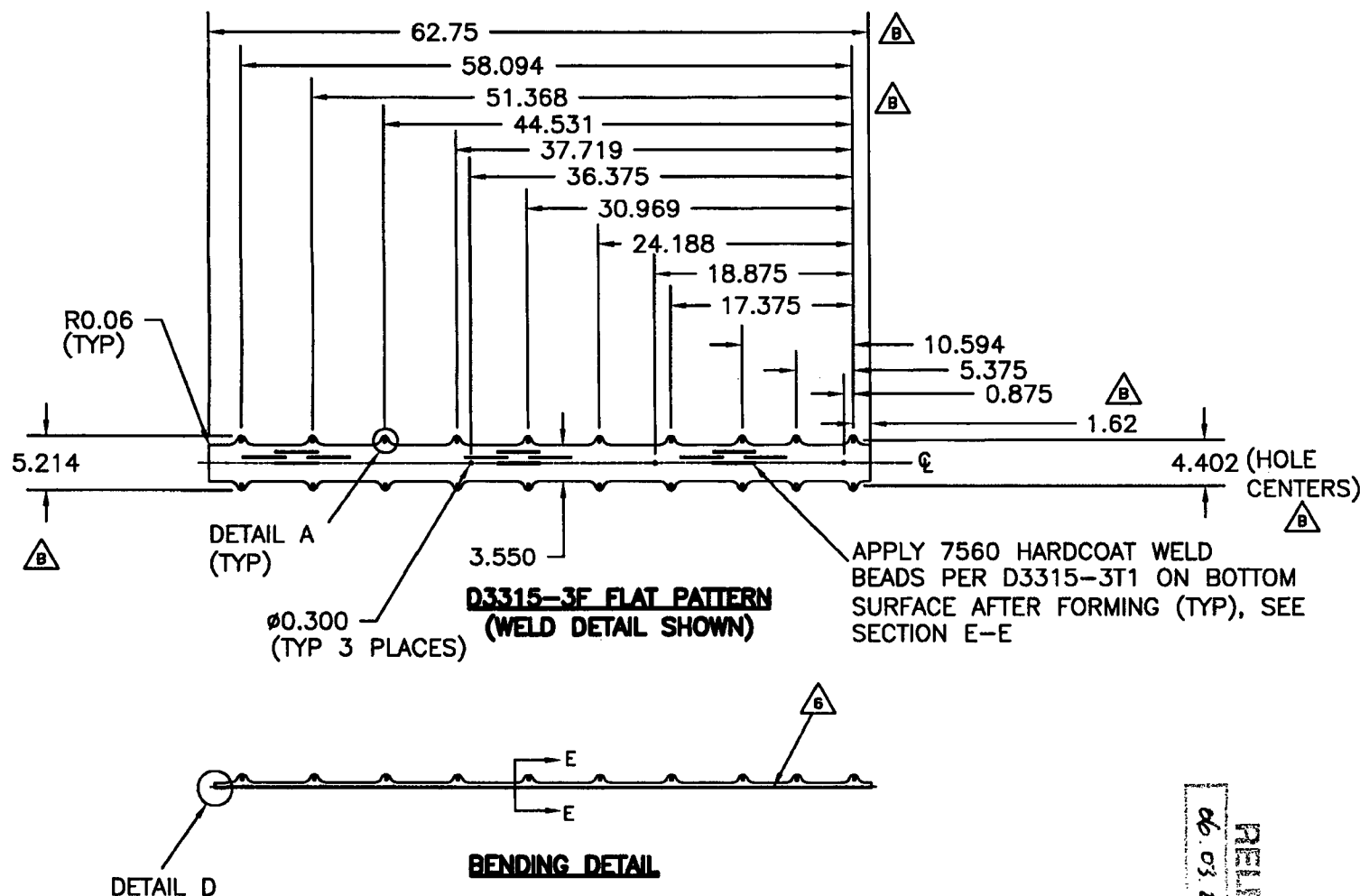
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DART

u/c 52227

DESIGN	DRAWN BY	DART AEROSPACE LTD	
04	04	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3315	SHEET 2 OF 4
DATE	TITLE	WEARPLATE	SCALE
06.01.31			1:18

**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

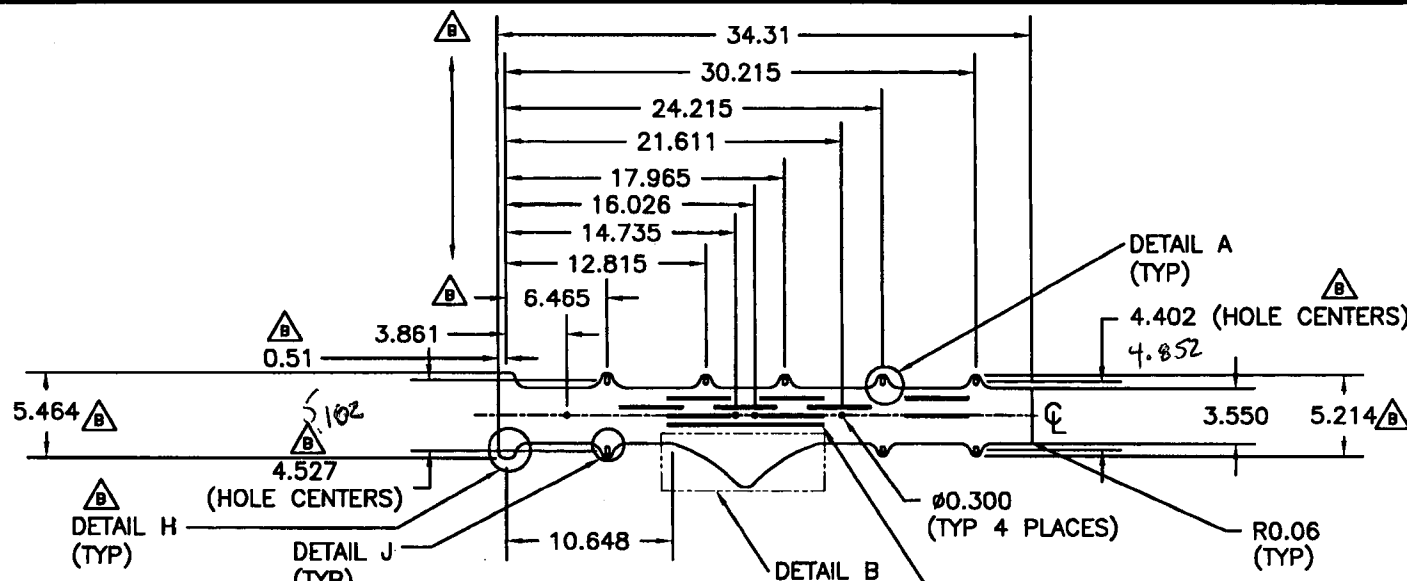
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- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED
06.03.20 *[Signature]*

DART

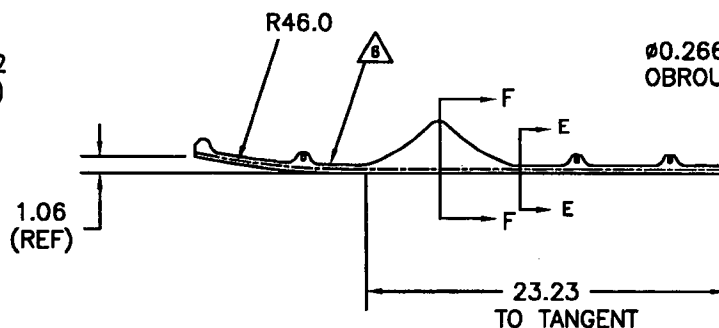
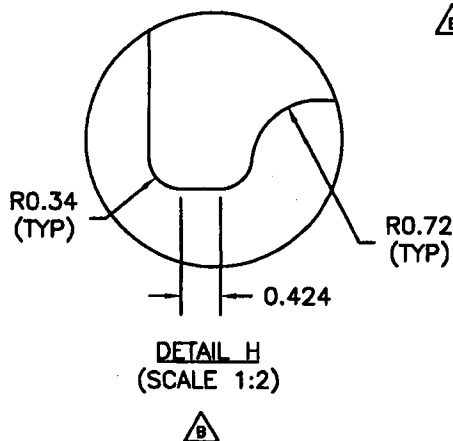
W/O 52227

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CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
TITLE	WEARPLATE	SHEET	3 OF 4	
SCALE	1:12			

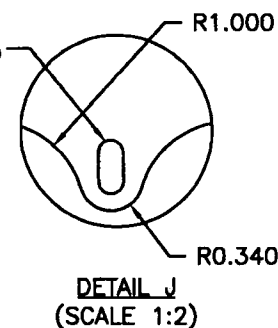


**D3315-5F FLAT PATTERN
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD
BEADS PER D3315-5T1 ON BOTTOM SURFACE
AFTER FORMING (TYP), SEE SECTION E-E



BENDING DETAIL



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
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 - 5) ALL DIMENSION ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- *TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

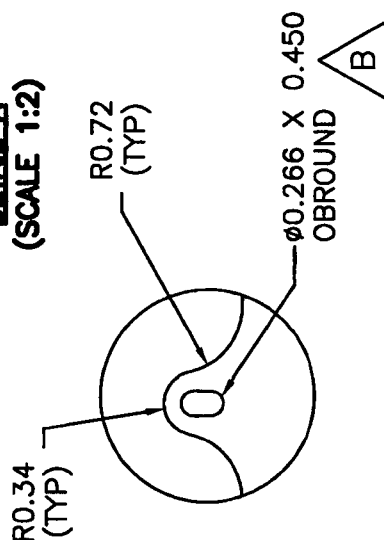
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06 03 20

DART

W/O 52227

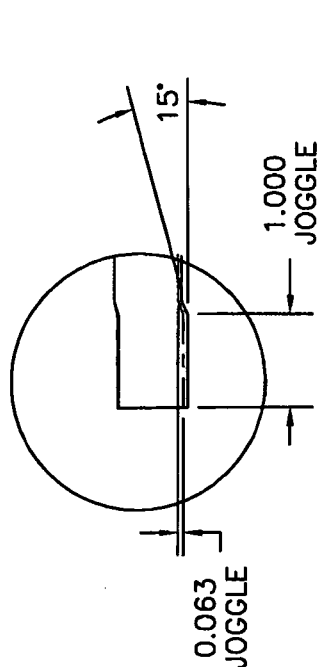
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CHECKED 	APPROVED 	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31		TITLE WEARPLATE	SCALE NTS

DETAIL A
(SCALE 1:2)

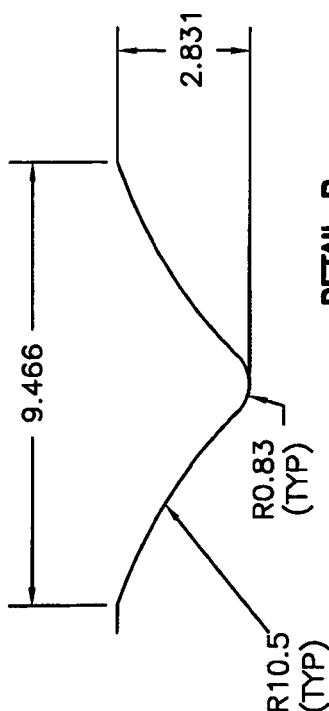


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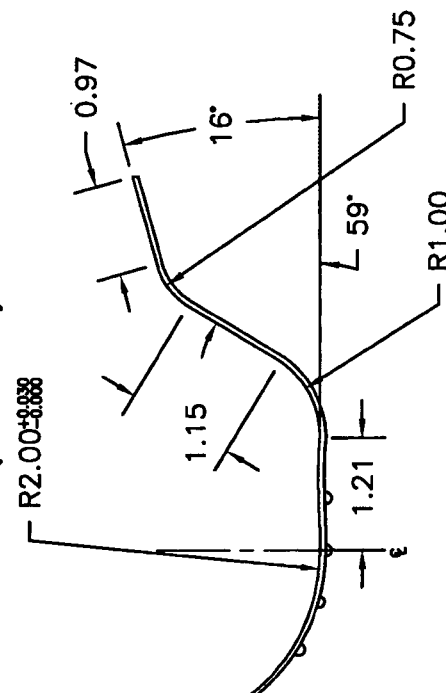
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DETAIL D
(SCALE 1:2)



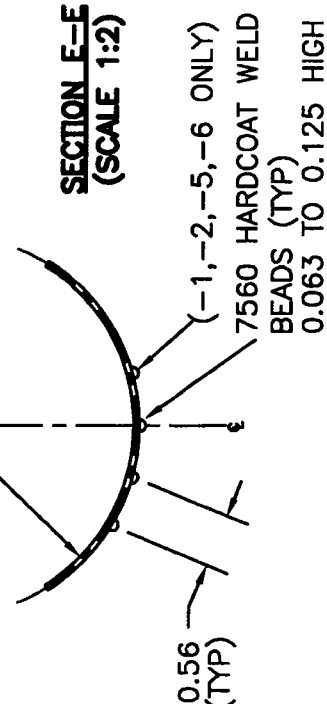
DETAIL B
(SCALE 1:4)



SECTION F-F
(SCALE 1:2)

R2.00^{+0.030}_{-0.000}

SECTION E-E
(SCALE 1:2)



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